

Work Order ID 82220

82220

Page 1

March-26-12 2:24:31 PM

Item ID: D3389-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Web

Stop *NS2*

Start Date: 26/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 09/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MCT

Date: 12/03/26 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3389

Rev D

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2500-3-100
2- Deburr
3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.
4- Cut to finished length
5- Open holes to finished size as per dwg D3389
6- Deburr

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

6 / CF 12-3-27

NP 12-3-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

6 CF 12-3-21

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

DP 12-3-28

PTO

140

Identify as per dwg & Stock Location: 46

0.00

140



Packaging

Memo

0.00

Packaging

DP 12-3-28

W/O: 82220		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-3-28	130	Standard QC7		12-3-28 12.3.29			

Part No: D3389-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/3/29

MF
12-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-26-12 2:24:35 PM

Page 1

Work Order ID: 82220

82220

Parent Item: D3389-1

D3389-1

Parent Item Name: Web

Start Date: 26/03/2012

Required Date: 09/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-02-08 As per Rev C JLM

IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

66.0000

1

D2500-3-100

**

Ext'n -1' Beam Web 4"

Location

Loc Qty

Loc Code

LG

66

51957

2

66298

3

79041

61

6

CF 12-3-26

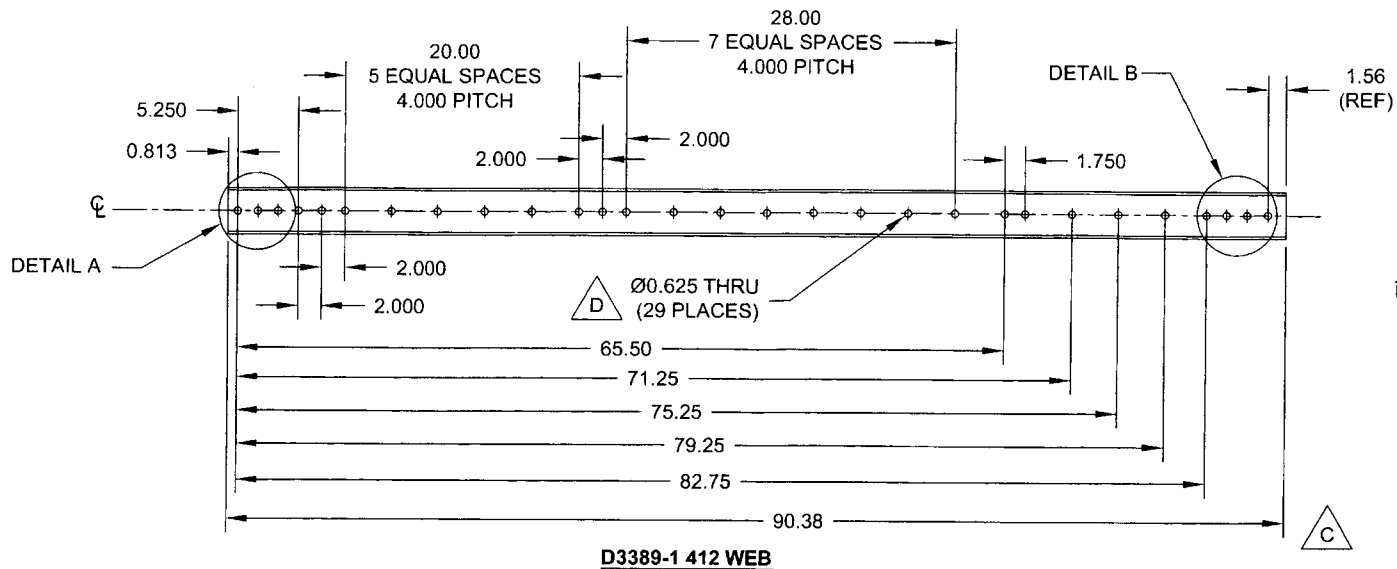
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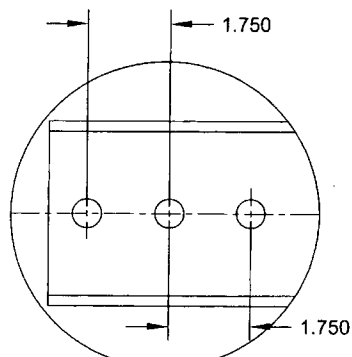
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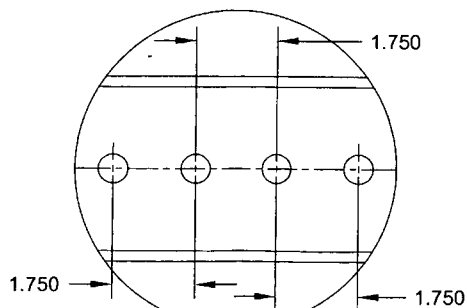
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06 MJD

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO. D3389	REV. D
TITLE 412 WEB	SHEET 1 OF 1
	SCALE 1:10

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82220

MLJ

12/03/26

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